

Work Order ID 79233

79233

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January-24-12 9:56:10 AM

Item ID: D3413-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Ring
 Start Date: 24/01/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 12/01/24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3413	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3413								
304 2004	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B 12-1-26

623

B 12-1-26

S 12/01/31

Count
 723

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Item Name: Ring
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

155		0.00							
155									
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>117319</u> DELFLEET BLUE B <u>118395</u> CLEAR DELFLEET B <u>118093</u>								

Handwritten signature and date 12/01/31 with circled 23

Handwritten circled X23

Handwritten date 12-2-11 and signature Pto with circled 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3413-1 PAR #: _____ Fault Category: Finish / wet Paint NCR: Yes No DQA: AK Date: 12/2/17
 Resolution: Rework Disposition: Rework QA: N/C Closed: CK Date: 12/2/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/09	#135	Paint has too many flaws in it R.C. Painter tries to paint too many parts at once.	S relalos 052042	Scud Qty #23. Re Paint as per as 1 005 in small Batches.	AK 12-2-9 AK 12-2-9	AK 12.02.13	S 12/02/09 052042	S 12/02/09

NOTE: Date & initial all entries

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Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ring
 Start Date: 24/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC14- Inspect Spray Paint	0.00							
165									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>57420</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12 12 02 13 (23)

12/02/14 (23)

12/02/14

12/02/14 (23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 79233

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Parent Item: D3413-1

D3413-1

Parent Item Name: Ring

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A05.09.13New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased			No	100	f	65.5000	0.25	5.263158	6,		
M304B0 250X4 000										**			
304 BAR .250 x 4.00													

1312-1-02

Location

Loc Qty

Loc Code

MAT050

65.5

119043

22.5

119766

31

119840

12

119766

(23)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

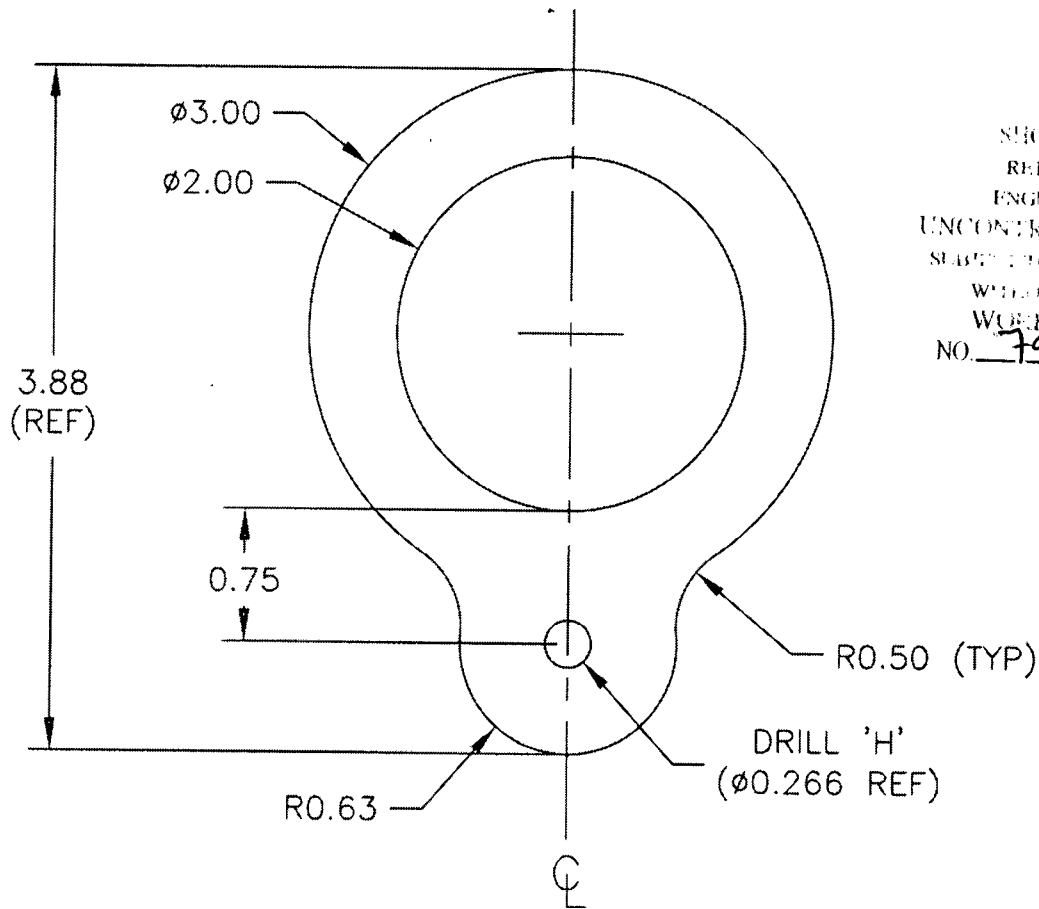
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 [Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REWORK
WITHOUT NOTICE
WORK ORDER
NO. 79233 M.L.J.

12/01/24

D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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